

Work Order ID 66593

Page 1

Tuesday, February 22, 2011 1:27:11 PM

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PA*Date: *11-02-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

13537

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

PA 11-02-22
Q

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Rec'd 4/14
Q

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66593

Page 2

Tuesday, February 22, 2011 1:27:11 PM

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 2/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00				<u>ML</u>	<u>11</u>	<u>04</u>	<u>14</u> ①
QC Quality Control	Memo Check for void spot and pins.	0.00							
130 	Identify as per dwg & Stock Location: <u>w/obbsgk</u>	0.00							
Packaging Packaging	Memo <u>Per 4657</u>	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/4/14 ①11/4/14 ②11/4/14

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 1:27:17 PM

Page 1

Work Order ID: 66593



Parent Item: D3186-2M



Parent Item Name: SPACEPOD DOOR RH


Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P  Spacepod Door		Purchased	No			110	Each	0.0000	1	1			



Paul G/14 (1)

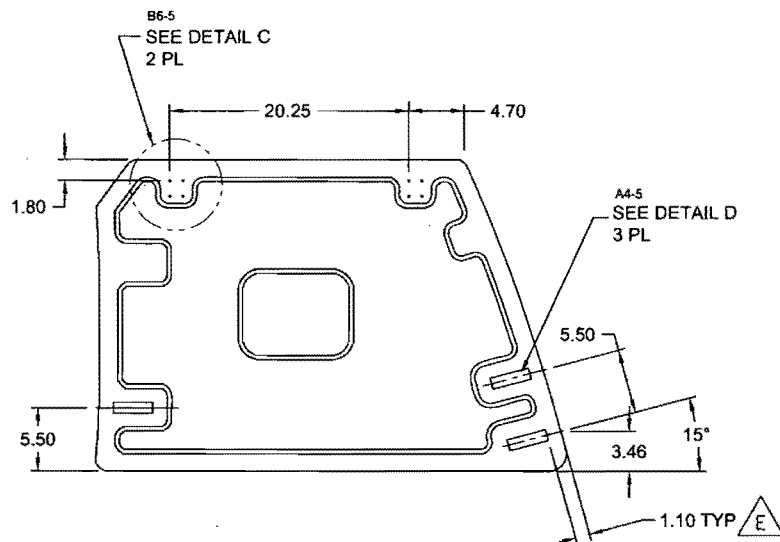
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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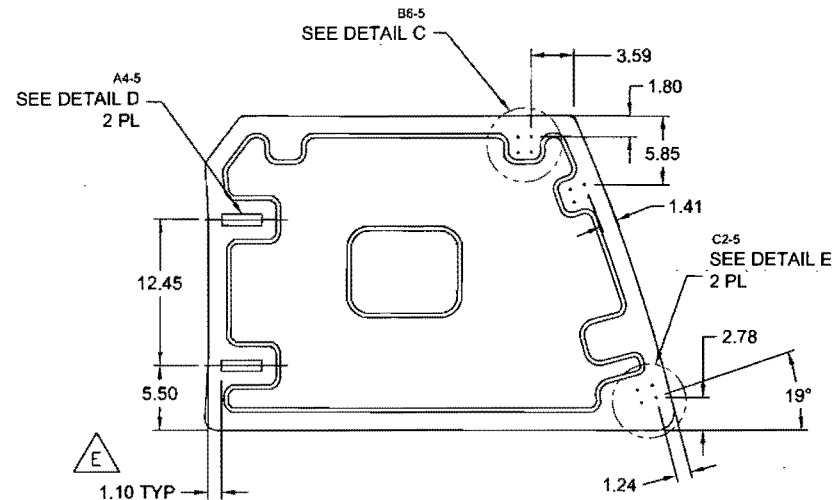
NOTE: Date & initial all entries



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026		RF	09.07.08
D	UPDATE DIMENSIONS		LE	07.02.22
C	REMOVED D0600-XXX LABELS		LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED		LE	06.09.25
A	NEW ISSUE		CP	03.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	JP	DRAWING NO.	REV. E	SHEET 1 OF 5
MFG. APPR.	JP	D3186		
APPROVED	JP	TITLE	SCALE	
DE APPR.	JP	SPACEPOD DOOR	NTS	
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

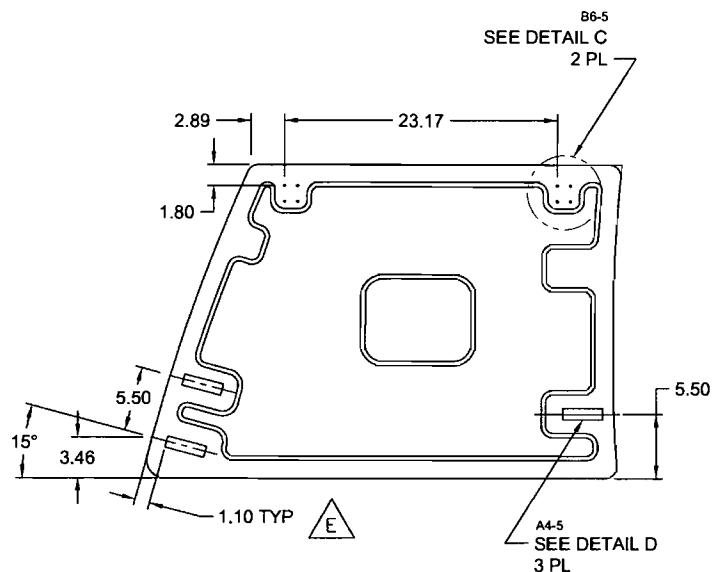
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

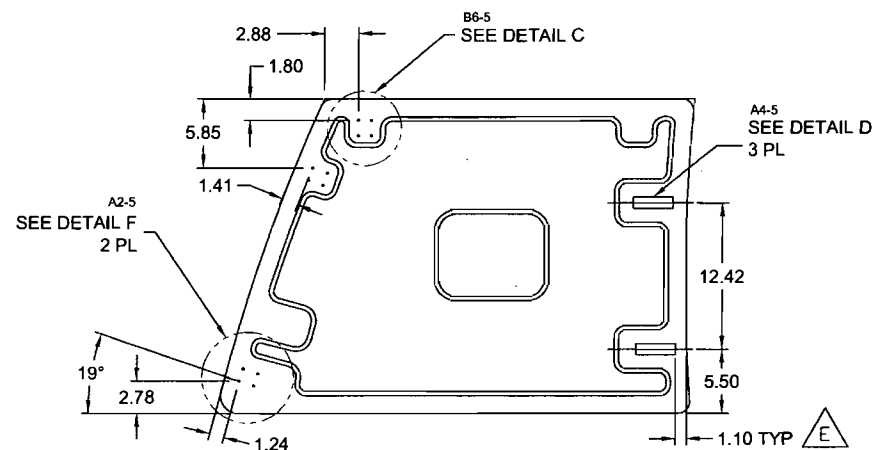
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M







D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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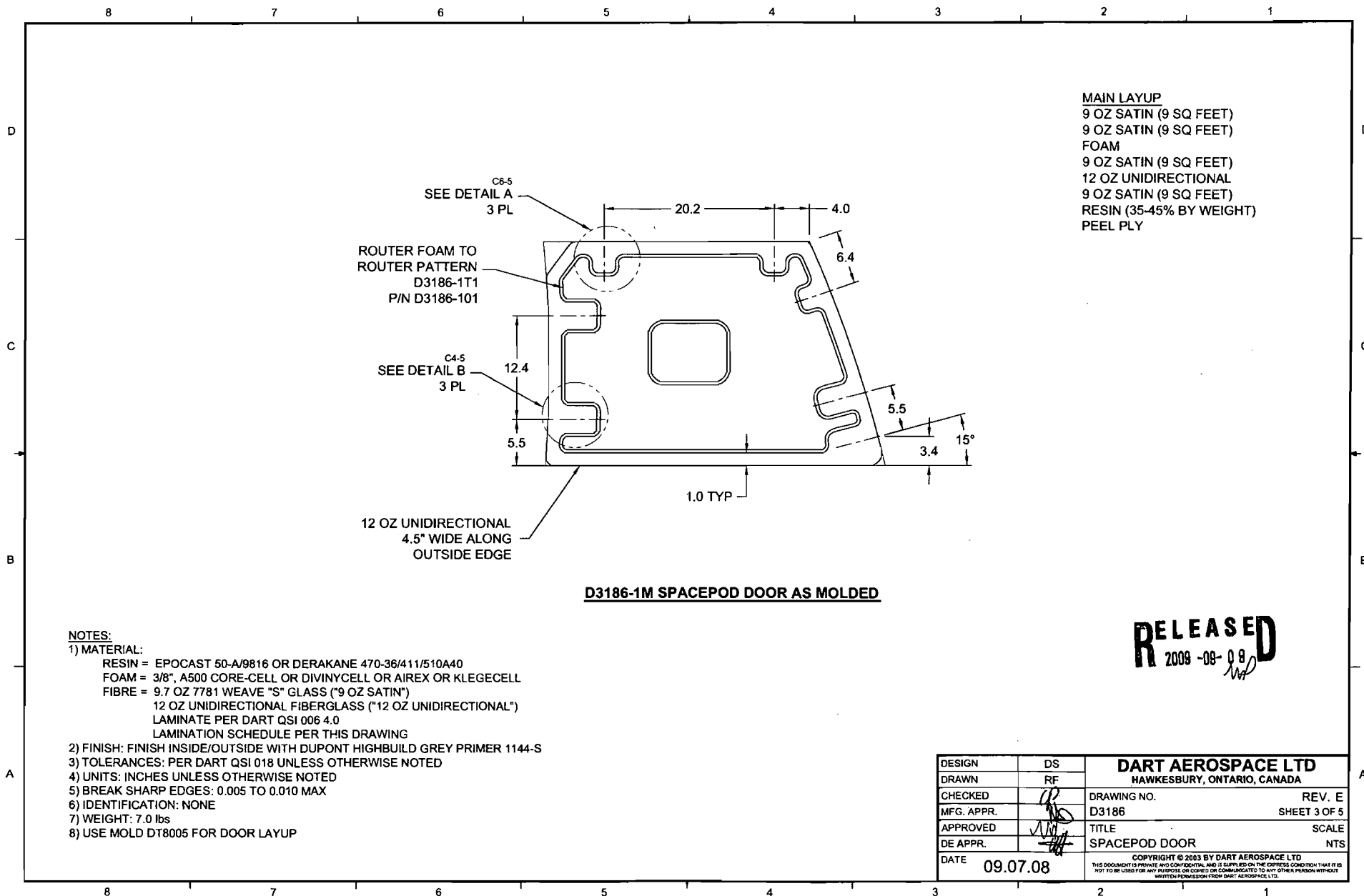
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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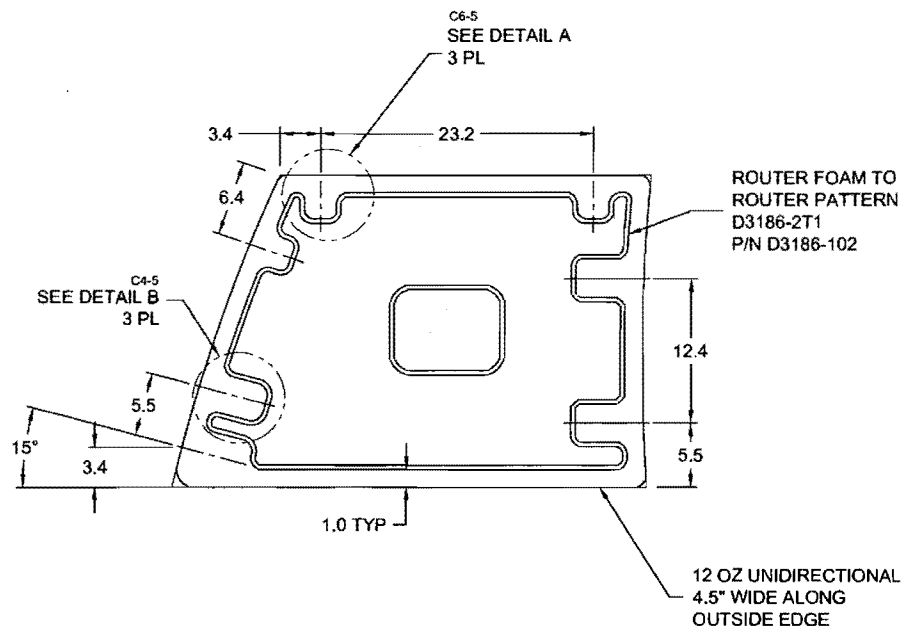
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NOTE: Date & initial all entries

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX




6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2009-09-08

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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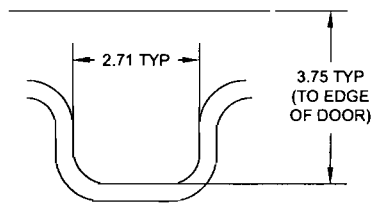
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

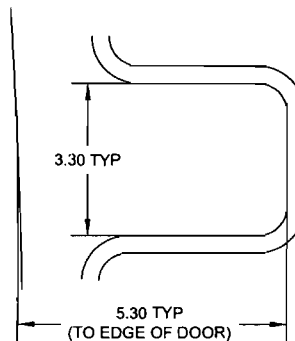
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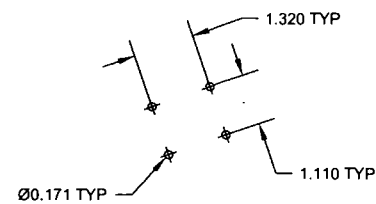
NOTE: Date & initial all entries



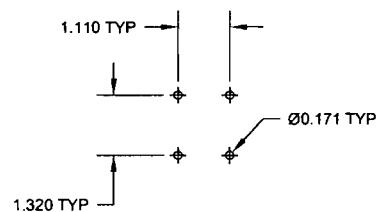
DETAIL A D6-3
SCALE 4X D4-4



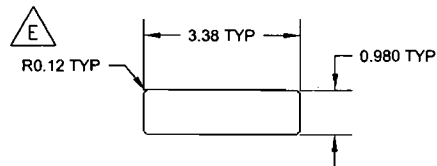
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

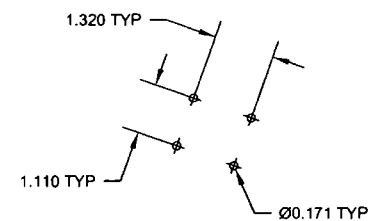


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3186	REV. E SHEET 5 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE SPACEPOD DOOR	SCALE NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13537

Purchase Order Date 2/22/2011

PO Print Date 2/23/2011

Page Number 1 of 1

Order From : VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	819 533 5788	Requisition Nbr	
Vendor Fax	819 533 3494	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	D3186-2P	Spacepod Door	3/21/2011 Yes	✓ 1.00 Each	Purolator ground	\$711.0000	\$711.00
		Special Inst:	As per Dwg: D3188 Rev:F B#66594				
3	D3186-2P	Spacepod Door	4/15/2011 Yes	✓ 1.00 Each	Purolator ground	\$711.0000	\$711.00
		Special Inst:	B66593				
	D3188-2P	Spacepod Body	3/21/2011 Yes	✓ 1.00 Each	Purolator ground	\$2,177.0000	\$2,177.00
		Special Inst:	As per DWG: D3188 Rev: F B66597				
	D3188-2P	Spacepod Body	4/15/2011 Yes	1.00 Each	Purolator ground	\$2,177.0000	\$2,177.00
		Special Inst:	B66602				
PO Total:							\$5,776.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 2/23/2011



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	38005
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:
DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

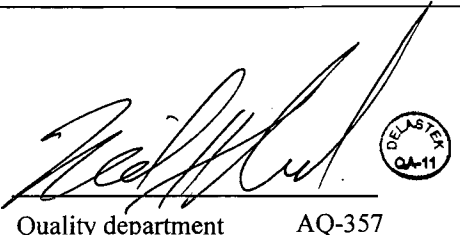
Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms	Salesperson
PURO GROUND		Origin		Net 30 days USA	Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
13/04/2011	22/02/2011	16857	Brigitte Golden	PO135374	
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	
1	0	1	DKC134-0060	Line 2 D31862P Spacepod Door RH B66593 Dwg. Rév.: E No. série B66593 No. lot 31894 U de M : Each	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


Quality department AQ-357



Date: Mardi, 2011-02-22 17:21:45
 Utilisateur: Pascal Carignan

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	SPACEPOD DOOR RH
Numéro Job :	31894	Numéro Article :	DKC134-0060
Numéro Soumission :	3769	Numéro Dessin :	D3186
Numéro B.A. :		Projet Numéro :	DK-359
Cette fois :	2011-02-22	Révision dessin :	E
Prsht Rev. :	NC	Matériel :	7781 & 411-350
Prem. fois :	- -	Date Dûe :	2011-03-01
Job précédente :	31893	Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Client: D31862M		

**B 66593**

Process Sheet Rév.: 01 changer le sikkens AAC1390 pour le P15-3
 (AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le
 Wolo

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) N° 83634, Frekote Loctite Wolo # de Lot: _____		
2.0	PRÉPARATION	Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min **Total Run :** 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: _____ Sceau: _____

3.0	AC0883	Tissu à délaminer Release ply B
Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)		
4.0	AC0884	Wrightlon 5200 Bleu P3
Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)		
5.0	AC0885	Feutre de drainage N° Airweave N 10
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)		
6.0	AC0943	Stretchlon 200 poche à vide Vert
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)		
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish		

N° de Lot: **1-28776-2**

Date: Mardi, 2011-02-22 17:21:45

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 31894

Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

8.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total: 2.2500 ROULEAU(s)

9.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE(s)/Unit Total: 1.00 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

10.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 01-03-11 Sceau:

11.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0080 GALLON(s)/Unit Total: 0.0080 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

12.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 LITRE(s)/Unit Total: 0.500 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-29826-1

13.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 1/03/11 Sceau:

14.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 1/03/11 Sceau:

Date: Mardi, 2011-02-22 17:21:45

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 31894

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

15.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 10:30

Heure Fin Curing: 8:00

Date: 7/03/11

Sceau:



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-29826-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 2/03/11

Sceau:



19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Job: 31989

20.0

AAC1611

Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)

Polybond B46F

N° de Lot: 1-277295-1

21.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Date: Mardi, 2011-02-22 17:21:45

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 31894

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description:

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 8/03/11 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:25

Heure Fin Curing: 11:45

Date: 8/03/11 sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentaire Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-29826-1

25.0

PREP-GENERAL

Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 9/03/11 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 9/03/11 Sceau:



Date: Mardi, 2011-02-22 17:21:45
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 31894

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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27.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 1:15

Heure Fin Curing: 8:00

Date: 9/03/11

sceau:



28.0	DÉMOULAGE	Démoulage de la pièce
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 10-3-11 Sceau:



29.0	TRIMAGE	Trimage
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 11-3-11 Sceau:



30.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s) (2)
Dupont Primer N° 7704S N° de Lot: 1-29264-2

31.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-28961-3

32.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008.

1^{er} couche
Date: 14 mars 11 Sceau:



2^e couche
de fiche de mélange: NA

Date: Mardi, 2011-02-22 17:21:45
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 31894

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description:

33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total: 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler

1-29667-1



CC. 2/3/2011

34.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 24-3-11 sceau:



35.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total: 0.1400 UNITE(s)
Dupont Primer N° 7704S

de Lot: 1-29624-2

36.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0300 UNITE(s)/Unit Total: 0.0300 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase

de Lot: 1-29177-3

37.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 4 avril 11 sceau:



de Fiche de mélange: 10/14

38.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 24 avr 11 sceau:



39.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 12 avril 11 sceau:



